

SPLIT

Work Order ID 59245-2

May 28, 2010 7:49:48 AM

PRELIMINARY ISSUE



Page 1

Item ID: D4127-1

Revision ID: PRELIM

Item Name: Lug

Start Date: 28/05/2010 Start Qty: 5.00

Required Date: 28/05/2010 Req'd Qty: 5.00

Reference:

4.09N
10-5-28

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4127

PA1

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per Dwg

DWG REV: PRE

PROG REV: LUM

DEBURR IF REQUIRED

10-5-28

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-5-28

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Page 2

Item ID: D4127-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Lug

Stop



Start Date: 28/05/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 28/05/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL RADS, DRILL HOLES AS PER DWG
GRIND RAD .060"-.100" BY HAND

SA 10/06/02

4

140

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SA 10/06/02

4

150

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

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Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Lug

Start Date: 28/05/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 28/05/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Work Order ID 59245

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Item ID: D4127-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Lug

Stop



Start Date: 28/05/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 28/05/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PARTS SCRAPPED FOR
LINDA LACELLE

200337 Feb

2010030

206 Float skip Mod

POSITIVE RECALL
EFFECTIVE 05.10
RELEASED AUTH W
DATE

U 08.07

Picklist Print

Page 1

May 28, 2010 7:49:48 AM

Work Order ID: 59245



Parent Item: D4127-1



Parent Item Name: Lug

Start Date: 28/05/2010

Required Date: 28/05/2010

Comments: IPP REV:A NEW ISSUE 10-05-28 JLM VERIFIED BY:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	46.0800	0.35	1.842289			



6061T6 BAR .750 X 6.00



1810-5-28

5

Location

Loc Qty

Loc Code

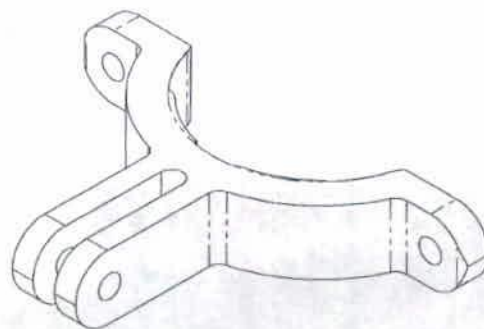
MAT03

46.08

112567

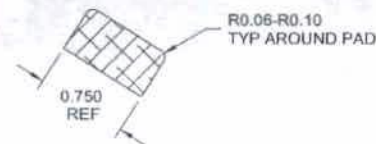
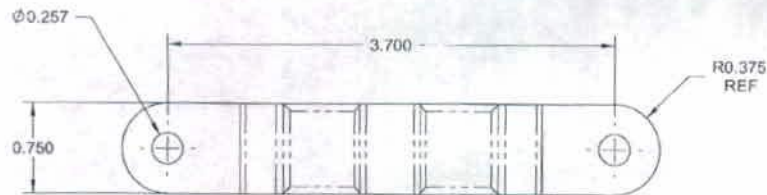
46.08

112567

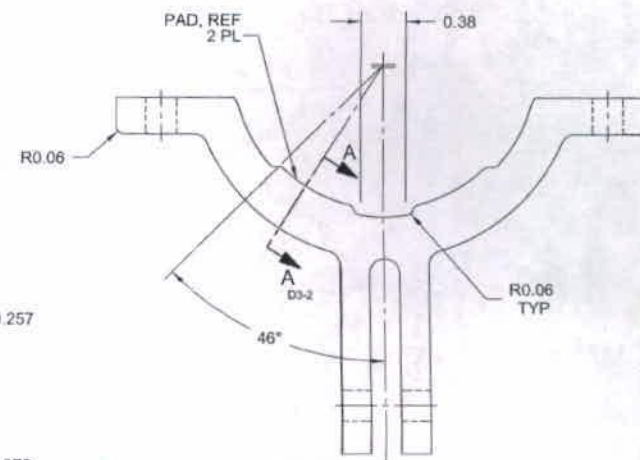
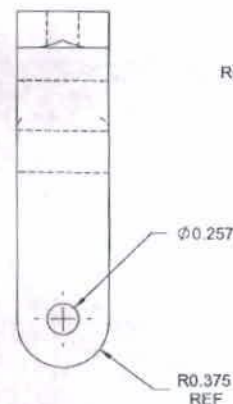
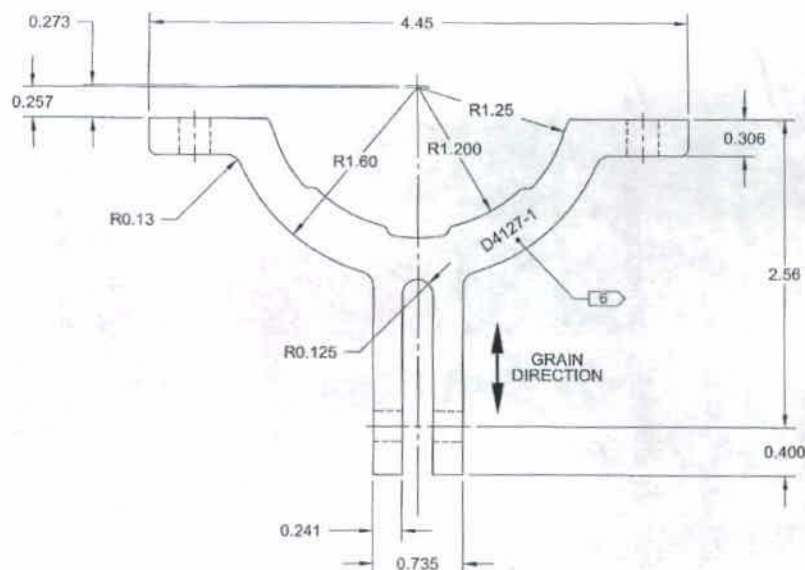


D4127-1 LUG

A	NEW ISSUE	MB	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4127	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	10.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DRAWING IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



SECTION A-A
SCALE 1X



D4127-1 LUG

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4127	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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